Batch Req. JM

Work Order ID 67829

Thursday, March 31, 2011 1:13:09 PM

Item ID: D2432 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: 206 (24") Bearpaw

Start Date: 3/31/2011 **Start Qty:** 16.00 **Cust Item ID:**

Required Date: 4/4/2011 **Req'd Qty:** 16.00 **Customer:**

Reference:

Approvals: **Process Plan:** M **Date:** 11-03-31 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Draw Nbr	Revision Nbr
D2432	Rev F3

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	FLOW WATER JET	0.00				B11-4-14			
Waterjet	**Memo**	0.00							
FLOW CNC Waterjet	Cut Blank as per D2432 File								
130	HAAS CNC VERTICAL MACHINING #1	0.00				19	0		
HAAS 1	**Memo**	0.00	ark 11/04/20						
HAAS CNC vertical machine #1	1-Inspect material for defects or damage prior to machining 2-Machine as per Folio and Dwg D2432 Identify as D2432F 3-Deburr								
140	QC2- Inspect parts off machine FAI/FAIB	0.00	ark 11/04/20			19	0		
QC	**Memo**	0.00							
Quality Control									

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 67829

Thursday, March 31, 2011 1:13:09 PM

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Revision ID:

Item Name: 206 (24") Bearpaw

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC8- Inspect parts - second check	0.00				19	0		
	Memo	0.00 BA 11/04/26							
151 Packaging Packaging	Identify as per dwg & Stock Location:_____	0.00							
	Memo PPP 16x 678		Full 4/25						
190 QC Quality Control	QC21- Final Inspection - Work Order Release	0.00						11/4/27	
	Memo	0.00						MF 11-04-27	

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Picklist Print

Thursday, March 31, 2011 1:13:14 PM

Work Order ID: 67829

Parent Item: D2432

Parent Item Name: 206 (24") Bearpaw

Start Date: 3/31/2011 **Required Date:** 4/4/2011

Start Qty: 16.00 **Required Qty:** 16.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	72.0000	3.7	59.2			
UHMW 1" Black													

Location	Loc Qty	Loc Code
MAT018	72	
116554	16	
116797	56	

B11-4-15

116554

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DART AEROSPACE LTD	Work Order:	67829
Description: Bearpaw	Part Number:	D2432
Inspection Dwg: D2432 **Rev:** F3		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	.055X45°	—		Vern HL-7	
B	5.500	+/-0.030	5.505	—		"	
C	0.200	+/-0.030	.197	—		"	
D	0.25 x 45°	+/-0.030	.275X45°	—		"	
E	R0.250	+/-0.030	R.250	—		Rad-gage	
F	0.250	+/-0.010	.246	—		Vern HL-7	
G	0.625	+/-0.030	.621	—		"	
H	0.375	+/-0.010	.383	—		"	
I	0.950	+0.030/0.010	.956	—		"	
J	19.000	+/-0.030	19.000	—		M-tape ML-02	
K	3.14	+/-0.030	3.136	—		Vern HL-7	
L	3.28	+/-0.030	3.285	—		"	
M	Ø0.260	+0.005/-0.000	Ø.266	—		"	
N	Ø0.93	+/-0.030	Ø.927	—		"	
O	0.30	+0.030/-0.000	.303	—		"	
P	23.750	+/-0.030	23.750	—		M-tape ML-02	
Q	7.375	+/-0.030	7.375	—		"	
R	4.250	+/-0.010	4.250	—		"	
S	2.000	+/-0.030	2.000	—		"	
T	9.000	+/-0.010	9.000	—		"	
U	9.000	+/-0.010	9.000	—		"	
V	0.375	+/-0.010	.378	—		Vern HL-7	

Measured by:		Audited by:	B.A	Prototype Approval:	N/A
Date:	11/04/26	Date:	11/04/26	Date:	

Rev	Date	Change		Revised by	Approved
A	04.01.09	New Issue	P/O K10008/D206-559-015	KJ/RF	

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NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO CHANGEMENT
WITHOUT NOTICE
WORK ORDER
NO. 47829 01-03-31

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
KE	KE		
CHECKED	APPROVED	DRAWING NO.	REV. F
MM		D2432	SHEET 1 OF 2
DATE		TITLE	SCALE
98.05.12		BEARPAW	1:6

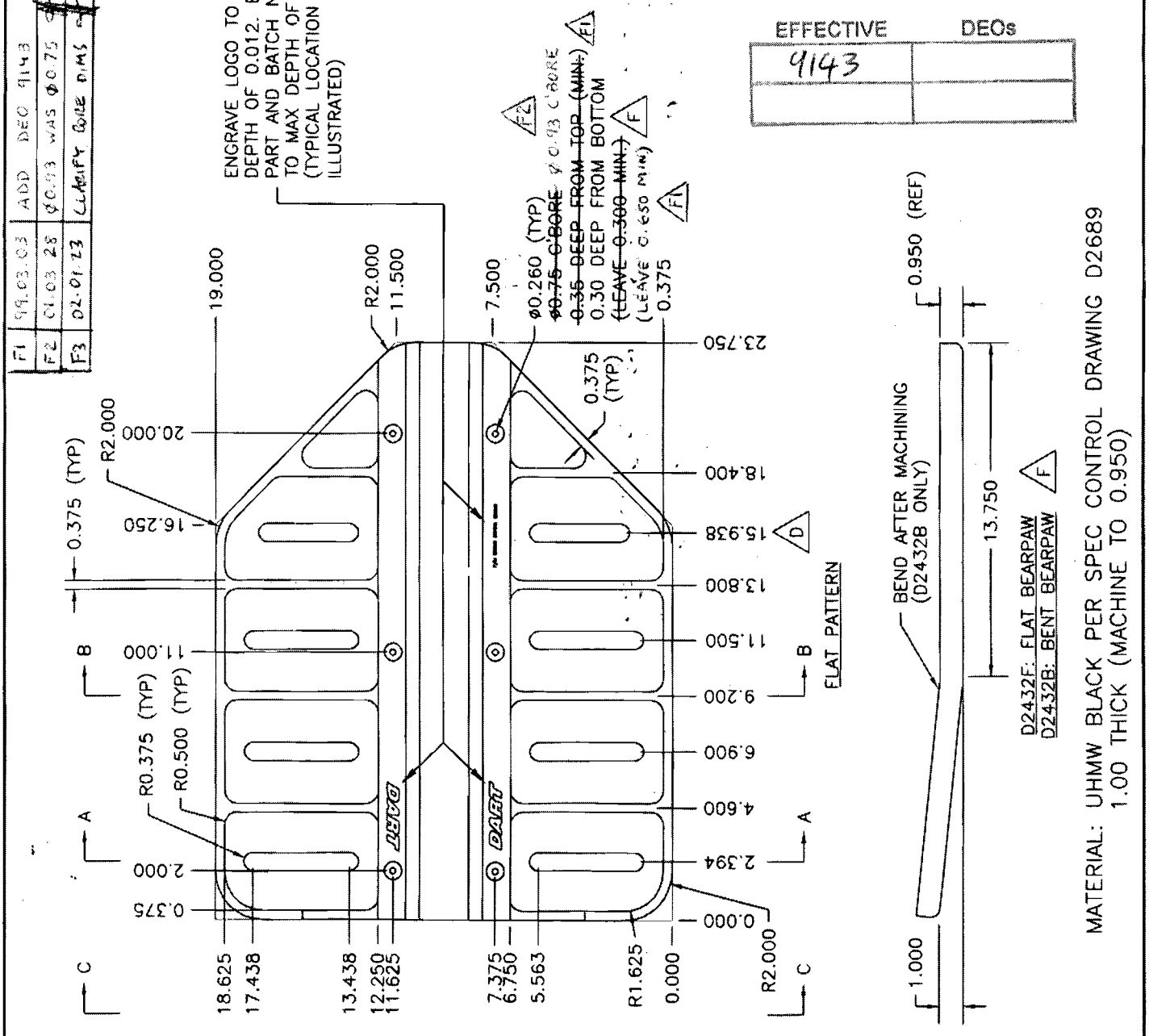
A	95.10.31	NEW ISSUE
B	96.01.24	RE-DESIGN
C	96.03.26	CHANGE BORE AND C'BORE DEPTH
D	96.06.04	MOVE SLOT
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N

RELEASED
98.06.17 KE

F1	99.03.03	ADD DEC 9143	RF
F2	01.03.28	Ø0.03 WAS Ø0.75	RF
F3	02.01.23	CLARIFY BORE DIMS	RF

EFFECTIVE DEOs

9143	



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